

# Work Order ID 52985

October 20, 2009 11:54:27 AM



Page 1

Item ID: D3453-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Plug

Start Date: 27/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *BL*

Date: *09-10-20* Tooling:

Date:

QC:

Date: ,SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3453

Rev *A B*

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA581 & DWG D3453 , □ FOLIO  
REV: *AB* □ DWG REV: *AB* □ 2-DEBURR AS REQUIRED

*ref 09.10.26*

*10* *Ø*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ref 09.10.26*

*10* *Ø*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*SA 09/10/26*

*10* *Ø*

**Work Order ID 52985**

October 20, 2009 11:54:27 AM



Page 2

Item ID: D3453-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Plug

Start Date: 22/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 92

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.9/14/27 (10)

10

10-10-2809-10-27

# Picklist Print

Page 1

October 20, 2009 11:54:32 AM

Work Order ID: 52985



Parent Item: D3453-5RevB



Parent Item Name: Plug

Start Date: 22/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304R1.000

Purchased

No

100

f

61.0900

1.7368



304 round bar 1.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

61.09

109508

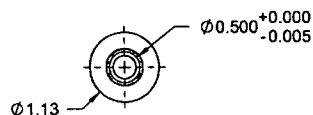
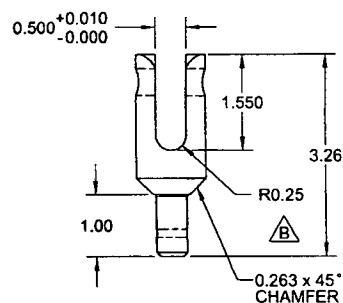
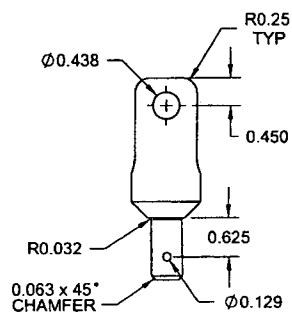
20.82

109541

40.27

*MP 09.10.26*

1.65



**D3453-1 CLEVIS**

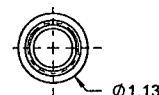
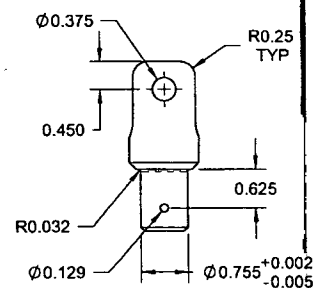
**D3453-1/-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs  
D3453-3 = 0.41 lbs

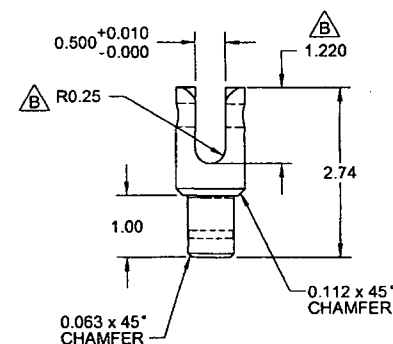
SHOP  
RETURN  
ENGINEERING  
CHECKED  
SUBMITTAL  
WORK

NO. 52985

PL 09-10-20

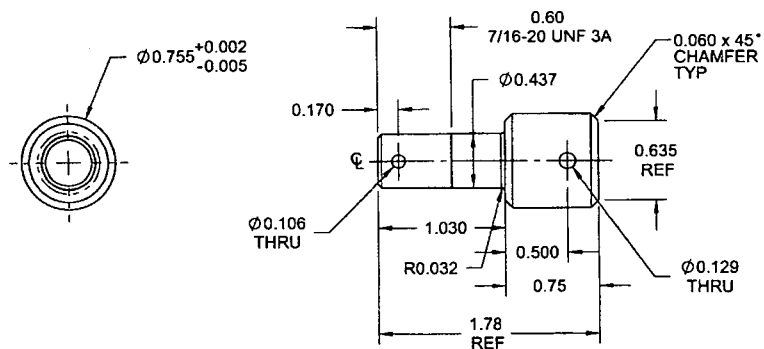


**D3453-3 CLEVIS**



RELEASED  
9/26/25

B	DRAWING UPDATED TO CURRENT STANDARDS: R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3453		REV. B	
TITLE CLEVIS		SCALE	
		NTS	
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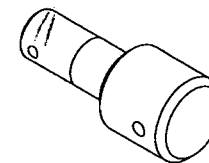


**D3453-5 PLUG**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52985

**D3453-5 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs



**RELEASED**  
09/05/25

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3453</b>	SHEET 2 OF 2
MFG. APPR.	<i>[Signature]</i>	TITLE <b>CLEVIS</b>	SCALE NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DOWNLOADED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order:	52985
Description: Plug		Part Number:	D3453-5
Inspection Dwg: D3453	Rev: <i>XP</i>	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.755	+0.002/-0.005	<i>-.754</i>	<i>/</i>			
1.030	+/-0.010	<i>1.030</i>	<i>/</i>			
0.75	+/-0.030	<i>-.75</i>	<i>/</i>			
0.60	+/-0.030	<i>-.60</i>	<i>/</i>			
7/16" x 20 UNF	N/A	<i>447 MDW</i>	<i>/</i>			
0.170	+/-0.010	<i>.172</i>	<i>/</i>			
0.500	+/-0.010	<i>.500</i>	<i>/</i>			
Ø0.106	+0.004/-0.001	<i>-.106</i>	<i>/</i>			
Ø0.129	+0.005/-0.001	<i>-.128</i>	<i>/</i>			
Ø0.429 - Ø0.437	N/A	<i>.434</i>	<i>/</i>			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>08.10.26</i>	Date: <i>08/10/26</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.09.06	Dimensions revised	KJ/JLM	
C	08.06.02	Ø0.429 - Ø0.437 dimension revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>